






# Work Order ID 65155

Thursday, January 06, 2011 3:32:25 PM


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Item ID:	D3257-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Fitting				Stop	
Start Date:	1/6/2011	Start Qty:	8.00	Cust Item ID:		
Required Date:	1/14/2011	Req'd Qty:	8.00	Customer:		
Reference:						


Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3257	Rev A1

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jcaspa Bandsaw	Cut blank: 0.500" x 0.500" x 1.180" long Bar		SL	11/03/22					

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA420 and Dwg D3257-1-Deburr-2- *****FINISH TAPPING PARTS BY HAND AS PER DWG D3257*****			cmk 11/03/31					

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control				cmk 11/03/31					

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Item ID: D3257-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 1/6/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		B.A 11/04/04		8	0		
140  Packaging Packaging	Identify as per dwg & Stock Location: <u>24</u>  Memo	0.00  0.00					11/4/4	51	00
150  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							11/4/5 MF 11-04-05

# Picklist Print

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Work Order ID: 65155

Parent Item: D3257-1

Parent Item Name: Fitting



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A 04.04.14 New issue KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B0.500X0.500		Purchased	No			100	f	10.6908	0.1092	0.919579			
<p>AISI 303 Bar .500 x .500</p>													



11/03/22

Location

Loc Qty

Loc Code

MAT53

10.6908

111571

10.6908

92

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	65155
<b>Description: Fitting</b>		<b>Part Number:</b>	D3257-1
<b>Inspection Dwg: D3257 Rev: A1</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.127	—		Vern HL7	
0.135	+0.010/-0.007	.129	—		"	
1.080	+/-0.010	1.084	—		"	
0.330	+/-0.010	.330	—		"	
0.385	+/-0.010	.385	—		"	
Ø0.191	+0.005/-0.000	Ø.193	—		"	
R0.193	+/-0.010	R.193	—		"	
0.887	+/-0.010	.887	—		"	
0.385	+/-0.010	.385	—		"	
0.192	+/-0.005	.191	—		"	
Ø0.230 x 100°	+/-0.010	Ø.235	—		"	
0.135	+0.010/-0.007	.129	—		"	

<b>Measured by:</b>	aml	<b>Audited by:</b>	K.A	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	11/03/31	<b>Date:</b>	11/04/04	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.06.20	0.455 dimension removed	KJ/JLM	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

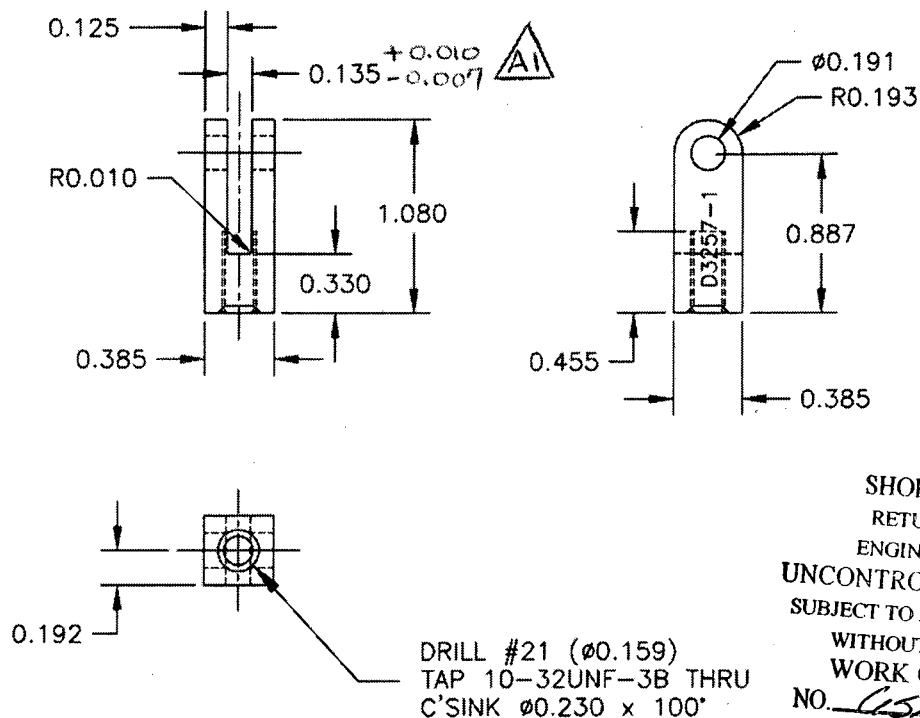
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3257	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE FITTING	SCALE 1:1
A	04.01.27	NEW ISSUE	
AI	04.12.14	ADD TOLERANCE	

RELEASED  
04.04.05 [Signature]



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 65155

BP11-01-7

### D3257-1 FITTING

#### NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: AISI 303 SS, BAR (REF DART SPEC. M303B0.500X0.500)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries